

Work Order ID 81995-2

81995

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March 21, 2012 3:05:29 PM

Item ID: D2807-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Door prop
 Start Date: 3/21/12 Start Qty: 40.00 *40* Cust Item ID:
 Required Date: 3/26/12 Req'd Qty: 40.00 *40* Customer:

Reference:

Approvals: Process Plan: *CL* Date: *12/03/21* Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2807	Rev E

100 PURCHASING 0.00
 100
 Purchasing Memo 0.00
 Purchasing Issue P/O: *16521* Order as per Dwg D2807 Possible
 supplier: Lift Support Technologies, Saskatoon, Canada P/N 6/15-164/50-115N
 Material release note is required

12-03-20

110 Receive & Inspect for Damage & Mat'l Certs 0.00
 110
 Packaging Memo 0.00
 Packaging Ensure Material Release Note is attached

14/3/23 *(40)*
14/4/18 *(25)*

120 QC6- Inspect dimensions to drawing 0.00
 120
 QC Memo 0.00
 Quality Control

8.7/4/20

cauter
(75)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Small Fab	Small Fab	0.00				25*	Ø		<i>[Signature]</i> 12/04/13
Small Fab	Memo 1-install D3671-1 as per dwg D2807	0.00							
140 *140* QC	QC5- Inspect part completeness to step on W/O	0.00							<i>[Signature]</i> 12/04/13
Quality Control	Memo	0.00							
150 *150* Packaging	Identify as per dwg & Stock Location: <u>8T 18</u>	0.00				25*			<i>[Signature]</i> 12-04-14
Packaging	Memo	0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

12-04-24

12/4/25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

March 21, 2012 3:05:28 PM

Page 1

Work Order ID: 81995
Parent Item: D2807-041
Parent Item Name: Door prop

Start Date: 3/21/12
Start Qty: 40.00

Required Date: 3/26/12
Required Qty: 40.00

Comments: IPP: D 07.11.12 ecn1019, replaces D2807 ECverified by DD
IPP Rev:E 08-02-12 ECN 1111 DD verified by: ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
6/15-164/50-115N Gas Spring		Purchased	No			130	Each	0.0000	1	40			
D3671-1 Placard		Manufactured	No			110	Each	12.0000	1	40			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				GA		12							
				80368		12							

Handwritten notes:
B12/10 (20)
B12/04/23
B81776

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

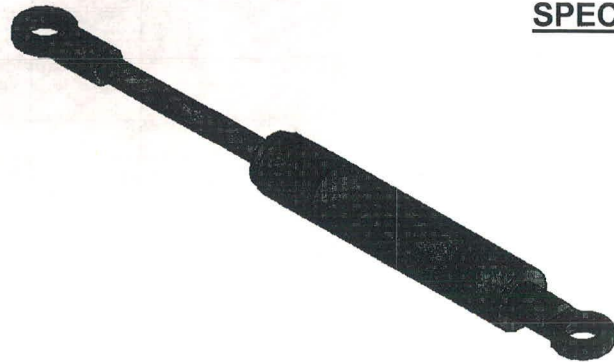
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING



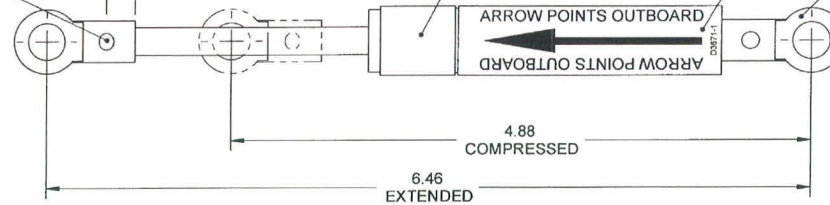
(8)
(ALTERNATE ONLY)
CRIMP 0.015-0.025 DEEP
WITH $\phi 0.375$ TOOL AT
2000psi (REF) TYP TWO
SIDES PER LUG

(8)
0.24 TO CRIMP
(TYP)

D2807-5
OR
(ALTERNATE ONLY) D2807-1

AFFIX D3671-1 PLACARD
ENSURE PLACARD DOES NOT
CONCEAL ANY TEXT OR MARKINGS
ON THE GAS SPRING

(8)
(ALTERNATE ONLY) D2807-3
BOTH ENDS



D2807-041 GAS SPRING

D2807-041 GAS SPRING ASSEMBLY PARTS LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D2807-041	GAS SPRING ASSEMBLY
1	D2807-5	GAS SPRING
1	D3671-1	PLACARD

CL 12103/21
W10! 81995

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.169 LBS
- 8) ALTERNATE PART: D2807-5 CAN BE MADE FROM ASSEMBLING D2807-1 (1) AND D2807-3 (2)
(WEIGHT: 0.176 LBS)

\triangle E

RELEASED

E	ADD D2807-5 GAS SPRING; D2807-1/-3 ASSEMBLY IS AN ALTERNATE TO D2807-5 GAS SPRING; UPDATE DIMENSIONS ON D2807-3	PH	07.12.28
D	ADDED D3671-1 PLACARD ADDED -041 ASSEMBLY UPDATED DWG	DC	07.09.27
C	CHANGE SPRING TO SS, ADD -3 LUG	CP	05.05.25
B	ADD FINISH	CP	05.03.16
A	NEW ISSUE	DS	00.11.03
REV.	DESCRIPTION	BY	DATE
DESIGN	AT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2807 TITLE GAS SPRING COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	AT		
CHECKED	KE		
MFG. APPR.	AT		
APPROVED	AT		
DE APPR.	AT		
DATE	07.12.28	REV. E	SHEET 1 OF 3
		SCALE	NTS

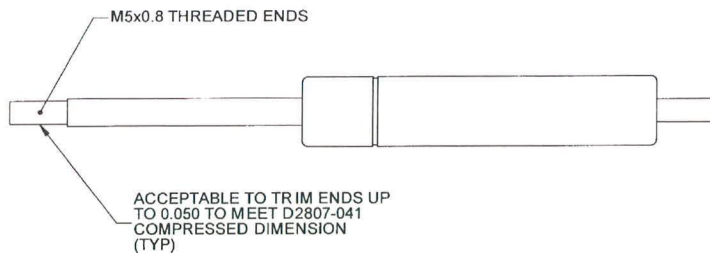
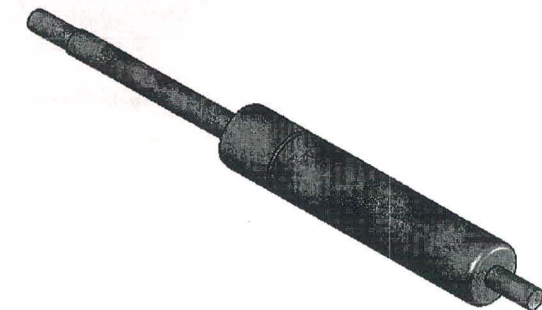
W/O:		WORK ORDER CHANGES					
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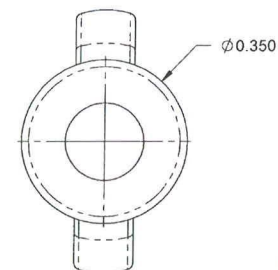
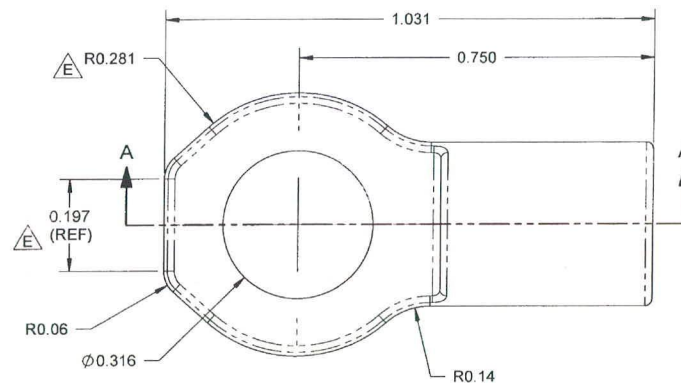
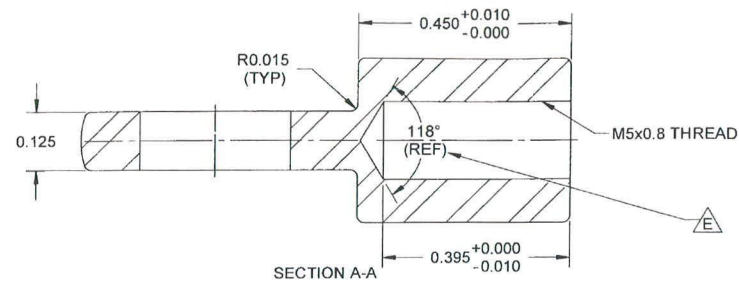
NOTE: Date & initial all entries



D2807-1 GAS SPRING
SCALE 1:1

D2807-1 GAS SPRING NOTES:

- 1) POSSIBLE SUPPLIER: ARVINMERITOR MOTION CONTROL SYSTEMS, LEICESTER, UK
(P/N SXF6S6050080S6L-115N)
(REF: 80MM LONG CYLINDER, 50MM STROKE, 115N LOAD)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.144 LBS
- 8) SPECIFICATION: SS GAS SPRING
ACCEPTABLE LOAD RANGE IS 25 LB (115 N) MIN TO 45 LB (200 N) MAX
M5x0.8 THREADS

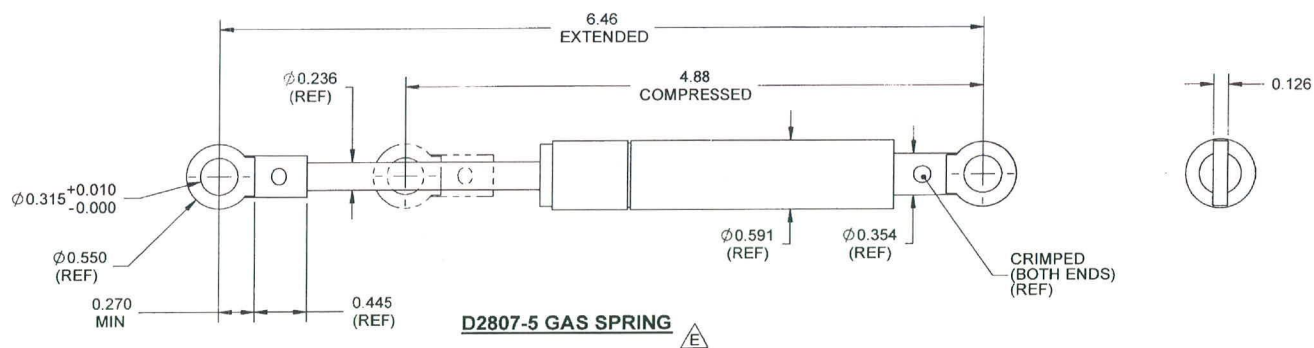
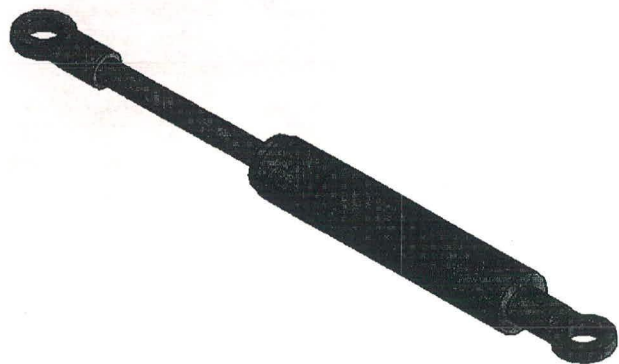


D2807-3 LUG

D2807-3 LUG NOTES:

- 1) MATERIAL: AISI 303 ROUND BAR (REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.015
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.016 LBS

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KE	DRAWING NO. D2807	REV. E
MFG. APPR.	KE	SHEET 2 OF 3	
APPROVED	KE	TITLE GAS SPRING	SCALE 4:1
DE APPR.	KE	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
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D2807-5 GAS SPRING



RELEASED
08-02-14

D2807-5 GAS SPRING NOTES:

- 1) POSSIBLE SUPPLIER: LIFT SUPPORT TECHNOLOGIES, SASKATOON, CANADA (P/N 6/15-164/50-115N)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.169 LBS
- 8) SPECIFICATION: SS GAS SPRING WITH END FITTINGS, ACCEPTABLE LOAD RANGE 25 LB (115 N) MIN TO 45 LB (200 N) MAX

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	KE	DRAWING NO. D2807	REV. E
MFG. APPR.	MP	SHEET 3 OF 3	
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	GAS SPRING	4:1
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO16521

Purchase Order Date 3/21/2012

PO Print Date 3/21/2012

Page Number 1 of 1

Order From :

VC-LST0001

LS TECHNOLOGIES INC.
314 JESSOP AVE
SASKATOON, SK S7N 1Y6
CA

Contact Name		Buyer	Brigitte Golden
Vendor Phone	306 683 5000	Requisition Nbr	
Vendor Fax	306 683 6403	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	CAD
		FOB	Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	6/15-164/50-115N	Gas Spring	3/23/2012 Yes	40.00 Each	FedEx Overnigh	\$63.9000	\$2,556.00

Special Inst: AS PER DWG: D2807 REV:E
B81995

PO Total: \$2,556.00

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 1

Change Date: 3/21/2012

LS TECHNOLOGIES INC

314 Jessop Ave
Saskatoon, SK S7N 1Y6

Ph # (306) 683-5000

Packing Slip

P.O. No.	Date	Invoice #
16521	16/04/2012	8500

Name / Address
Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship To
Main Finished Goods Location Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship	Via	FOB
16/04/2012		

Qty	Description
25	D2807 Stainless Gas Spring (6/15-164/50-115N) Shipping Via FED EX Tracking # 798290756004



LS Technologies Inc

314 Jessop Ave

Saskatoon, SK, S7N 1Y6

Ph: (306) 683-5000 Fax: (306) 683-6403

Certificate of Compliance

April 16, 2012

This is to certify that the parts listed below meets specifications as required by your order.

25 Units: D2807 Stainless Gas Spring (6/15-164/50-115N)

Country of Manufacture : Canada

Date of Manufacture : March 2012


This product is ROHS compliant.

5/2/12/20

Purchase Order # 16521

Inv# 8500

L S Technologies Inc Canada


Nolan Fehr
President

